Work Orde October-17-13		08405		*108	3405*						Page 1	
Item ID: Revision ID: Item Name:	D4093-5 Bracket		127 4 2	Accept	*N900	<b>040</b>	100	)* s	Setup Sta	1.7	S1* S2*	:
Start Date: Required Date: Reference:	10/17/13 10/17/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D;						
Approvals:		an: MLJ	_			ite:		F		art *N	IR1* IR2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Re	vision Nbr								_		
D4093 ,	D											
*100				0.00				8			Ac	
Waterjet FLOW CNC Waterj	et	Memo CUT AS PE DWG REV: PROG REV DEBURR	$\underline{C'}$	0.00							13.11	(,0
<sup>110</sup> <b>*11∩</b> *		QC2-Inspect parts off m	achine FAI/FAIB	0.00				P		0	A.	

13:11.08

0.00

Memo

Quality Control

												DQA:	Da	ite:	
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						DISPOSITION				AGAINST	— DE	PARTMENT			
Work Orde	er: .					_	,		. —			1			
						Rework	↓		Skid-tube	Crosstube	$\overline{}$		Water Jet	-	Engineering
Part N	۱o. ِ					Scrap	1		Machining	Small Fab	$\vdash$	4	d. Eng. Coor.		Quality
						Use-as-is		8	noforming	Finishing	-	Rec/Stor	e/Packaging		Other
NCR 1	No.					Work Order Update	ا ل		Large Fab	Composite		]	Supplier		
Root			<u> </u>		Descr	ription of work order update	T	Initial	A	ction		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Des	cription		Date	Verificatio	'n	QC Inspector
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	L	Bending			L	Bend		Grain			-	Ovalized		_	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		L	Over/Under		<u>_</u>	Temperature/Cure
	<u></u>	Cracks				Broken/Damaged	<u>_</u>	<b>-</b> 1 '	ion Incomplete		L	Part Incorred		L	Weld
1	L	Crushed/	Crimped			Burrs		Instruct	tions Incomplete	/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Orde		8405		*108	405*							Page 2
Revision ID: Item Name:	D4093-5 Bracket 10/17/13	Start Qty: 8.00	*8*	Accept	*N900		100	)*	Setup	Start Stop	14.	S1* S2*
Required Date:		Req'd Qty: 8.00	*8*		Customer:	2.						
Approvals:		in:				nte:			Run	Start Stop	!/	R1* R2*
Sequence ID/ Work Center II 120 *170* QC Quality Control	D	Operation Description QC8- Inspect parts - second	and check	Set Up/ Run HoupesS 0.00 27 9-89 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*130 *130* Small Fab Small Fab		<b>Memo</b> C' SINK AS	PER DWG	0.00			_	8				13/m/u
140 *1 <b>4</b> 0* QC		QC5- Inspect part compl	eteness to step on W/O	0.00 SY 0.00 B11	() ][			8				

Quality Control

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CON	IFORN	MANCE / UP	DATE	·		
										QA Closed:	Date:	
Work Orde	ır.				DISPOSITION	İ			AGAINST DE	PARTMENT	PROCESS	
WOIK OIGE	···		<del>,</del>	<del></del>	Rework	1 <b> </b>		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		oforming	Finishing	4	e/Packaging	Other
NCR N	lo				Work Order Update			Large Fab	Composite	]	Supplier	
Root	<u> </u>			Descri	tion of work order update	lı	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chi	ief Eng	Descr	ription	Date	Verification	QC Inspector
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Operator												
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Other		ł										
Process												
Supplier						-						
Training		ļ								•		
Unapproved												
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Landii	ng Gear				General					<b>-</b>	_	7
	Bending			<u> </u>	Bend	Ш	Grain		_	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/	'Crimped			Burrs	-		ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	-	Mainte		L	Part Moved		
•	Heat Trea	at			Countersink	Ш	Mislabe	led		Positioned V	Vrong	<b>-</b>
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	l .		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

W	ork	Order	ID	108405
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## \*108405\*

Page 3

Packaging

October-17-13	1:24:01 PM		· · · · · · · · · · · · · · · · · · ·										
Item ID: Revision ID: Item Name:	D4093-5 Bracket			Accept	<b>k</b>	<b>N900</b>	040	100	)* s	Setup S	tart z	۱۸۶ ۱۸۶	S1*
Start Date: Required Date: Reference:	10/17/13 10/17/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*			Cust Item I Customer:	D:						••
Approvals:	Process Pla	ın:	Date:	Tooling:		D	ate:		F			*NF	₹1*
	QC:		Date:	SPC (Y/N)	):	D	ate:			2	Stop	*NI	R2*
Sequence ID/ Work Center II	D	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Ho		Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		ect mber	Insp. Stamp
150		Chemical Conversion Co	at per QSI005 4.1	0.00							<b>~</b> "		
*150* HandFinish		Memo		0.00					8	Ø		- 1	3-11-1
160 *160* QC Quality Control		QC7-Inspect Chemical C	Conversion Coat	0.00	DAS 27 9-89				8	. <u></u>			
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*120* Packaging		Memo		0.00					·····Ø×	9-89			-14_

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NCR: Y	es / No				WORK ORDER NON-C	JINF.	UKIV	MANUE / UPD		QA Closed:	Date:	
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Part N	0.				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	Engineering Quality
	-			<del></del>	Use-as-is	7		oforming	Finishing		e/Packaging	Other
NCR N	lo				Work Order Update			Large Fab	Composite	•	Supplier	
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Landin	ng Gear				General							
[	Bending				Bend	G	rain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	На	ardwar	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	In:	spection	on Incomplete		Part Incorred	t 🗌	Weld
	Crushed/	Crimped			Burrs	In:	structi	ons Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	М	1ainte	nance		Part Moved		-
	Heat Trea	at			Countersink	Шм	lislabel	led		Positioned V	/rong	_
	Inspectio	n Strip in	Tube		Cut Too Short	М	lisread			Power Loss/	Surge	Other
	Ripples ir	n Bend			Drill Holes		ffset					
[	Torque W	laves in F	extrusio	n	Drawing		ut of C	alibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-17-13 1	r ID 10 1:24:01 PM			*108	3405*							Page 4
Revision ID:	D4093-5 Bracket			Accept	*N900	040	100	)*	Setup	Start Stop	*NS	\$1* \$2*
Required Date:	10/17/13 10/17/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:						
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Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	-		Insp.
190		QC21- Final Inspection	Work Order Release	0.00					1	2/1	1/18	94
*190* QC Quality Control		Memo		0.00							1 110 _ M	17-11-

											DQA	Date	e:
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Part N	-					Rework Scrap			Skid-tube Aachining	Crosstube Small Fab	Pro	Water Jet od. Eng. Coor.	Engineering Quality
NCR I	•				! 	Use-as-is Work Order Update		Therm	noforming Large Fab	Finishing Composite	}	re/Packaging Supplier	Other
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Cause		Date	Step	Qty	C	r Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector
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	-	Bending			, <u> </u>	Bend	$\vdash$	Grain			Ovalized	<b>-</b>	Pressure/Forced
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	-	Crushed/	Crimped		-	Burrs	-	-1	ions Incomplete/	Unciear	Part Lost/M		Wrong Stock Pulled
	-	Cuffs	- •		-	Contamination	$\vdash$	Mainte		<u> </u>	Part Moved		
	$\vdash$	Heat Tre		. T L .	_	Countersink	-	Mislabe		-	Positioned		
	<u> </u>	Inspection	-	ilube	_	Cut Too Short	-	Misread	i	<u> </u>	Power Loss	/surge	Other
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Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Page 1

Work Order ID:

108405

Parent Item:

D4093-5

Parent Item Name:

Bracket

**Start Date:** 10/17/13

Required Date: 10/17/13

Start Qty: 8.00

Loc Code

Required Qty: 8.00

Comments:

IPP REV:A NEW ISSUE 10-10-01 JLM VERIFIED BY:DD

Comments.													
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188		Purchased	No			100	sf	54.8200	0.025	0.2105264	. 1		~
6061-T6 .188 Sheet											Ai	<u> </u>	11.02

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work Orde	····			<del></del>	Rework	1		Skid-tube	Crosstube	]	Water Jet	Engineering
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					Use-as-is	1   7		oforming	Finishing	•	e/Packaging	Other
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	Cracks				Broken/Damaged	l	specti	on Incomplete		Part Incorred	ct	Weld
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	Inspectio	n Strip in	Tube		Cut Too Short	$\square$	lisread	l		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	По	ffset		-			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	108405
Description: Bracket	Part Number:	D4093-5
Inspection Dwg: D4093 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

		AITTIOLL III		T		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	.203	_		7	JKmc01
0.38	+/-0.030	,38	•		V	
0.75	+/-0.030	175			V	
4.64	+/-0.030	4.64	_			
3.889	+/-0.010	4.64 3.889			V	
0.188	+/-0.010	.188			~	
0.080	+0.005/0.001					
				-		
W						
			DAS			

Measured by: Ac		Audited by:	27 9-89	Preliminary Approval:	
Date: 13 · 11 · 0 §	•	Date:	13/1/08	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.10.07	New Issue	KJ	
В	11.07.26	Dwg Rev updated	KJ	
С	13.05.08	Dimensions updated per Dwg Rev C	KJ	
D	13.06.03	Dwg Rev updated	KJ 🕳	1.44

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